

Work Order ID 82583

April-03-12 10:34:53 AM

82583

Page 1

Item ID: D2803-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 03/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/03 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2803	Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per FILE D2803-1

Dwg Rev: 3

Prog Rev: 3

2-Deburr if necessary

6061 BAR
500 x 10.00

(12)

JM-NM
12-4-16

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA102

FK 12/05/28
PO - 12/05/29

12

Ø

(PTD)

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

FK 12/05/28
PO 12/05/29

12

Ø

W/O: 82583

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2803-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.05.31	110	Ø 0.507 hole is 0.001 below tolerance.	CP 12.05.31	Acceptable. Tag with a note to "CHECK WITH CP AFTER FINISH"	inf 12/05/31	S 12/05/31	CP 12.05.31 B142	S 12/05/31

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		enr12/05/31		12	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12		2612531	
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12	0	2612531	

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Reference:

Run Start ***NR1***

Stop ***NR2***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>ST-18</i>	0.00							
160									
Packaging	Memo	0.00				<i>12x</i>			<i>SP</i>
Packaging									<i>12-6-1</i>
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							<i>12/6/4</i>
Quality Control									<i>ME</i> <i>12-06-04</i>

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NOTE: Date & initial all entries

Picklist Print

April-03-12 10:34:59 AM

Page 1

Work Order ID: 82583

82583

Parent Item: D2803-1

D2803-1

Parent Item Name: Bracket

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A00.11.06New IssueEC

IPP Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM

IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased		No		100	f	22.5000	1.9167	24.21095			

M6061T6B0 500X10 000

**

6061-T6 Bar .500 x 10.00

Location

Loc Qty

Loc Code

MAT004

22.5

120421

22.5

120421

Jim. M
12-4-16

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82583
Description: Bracket		Part Number:	D2803-1
Inspection Dwg: D2803	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.759	✓		FK-01	Mic
Ø0.191	+0.005/-0.000	.192	✓		FK-04	Vern.
Ø0.507	+0.000/-0.001	.5063	✓		FK-01	Mic
13.558	+/-0.010	13.558	✓		FK-05	Tape
Ø0.507	+0.000/-0.001	.5062	✓		FK-01	Mic
12.411	+/-0.010	12.411	✓		CNC	
2.654	+0.000/-0.001	2.6533	✓		FK-01	Mic
0.437	+0.000/-0.001	.4362	✓		FK-01	Mic
1.420	+/-0.001	1.420	✓		FK-04	Vern.
6.933	+/-0.010	6.933	✓		CNC-02	Vern.
0.250	+/-0.010	.250	✓		FK-04	Vern.
0.875	+0.000/-0.001	.8743	✓		FK-01	Mic
0.250	+0.000/-0.005	.249	✓		FK-06	Depth gauge
0.125	+/-0.010	.130	✓		FK-04	Vern.
0.125	+/-0.010	.125	✓		"	"
0.125	+/-0.010	.130	✓		"	"
0.125	+/-0.010	.131	✓		"	"
0.500	+/-0.010	.503	✓		"	"
0.562	+/-0.010	.564	✓		"	"
0.188	+/-0.010	.188	✓		"	"

Measured by: F.R.	Audited by: <i>mf</i>	Prototype Approval:	N/A
Date: 12/05/28	Date: 12/05/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM <i>AF</i>	<i>BE</i>

W/O:		WORK ORDER CHANGES					
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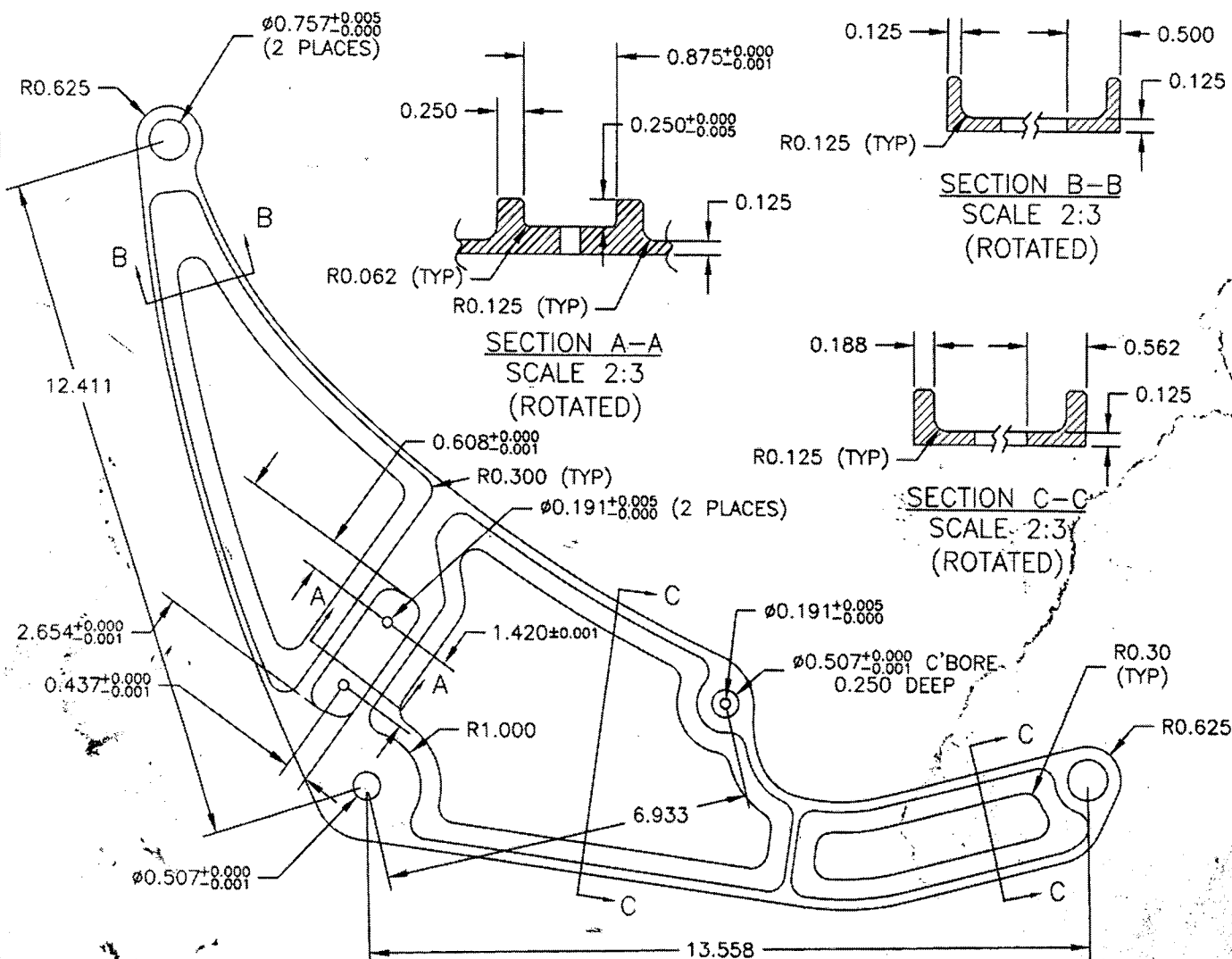
NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05-03 11 [Signature]

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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UNION
82583
12/04/03
[Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

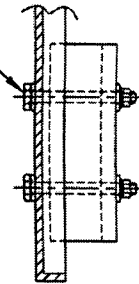
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NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION D-D
SCALE 1:3
(ROTATED)

USE D2803-1 FOR D2803-041/-043
USE D2803-2 FOR D2803-042/-044

USE D2805-1 FOR D2803-041
USE D2805-2 FOR D2803-042
USE D2805-3 FOR D2803-043
USE D2805-4 FOR D2803-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE
PRIOR TO POWDER COAT

RELEASED

05-03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN)
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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